

Date: Monday, 18/08/2008 10:22:42 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: <del>TUBE GUIDE</del> CLAMP
Job Number	: 41277	Part Number	: D34403
Estimate Number	: 10486	Drawing Number	: D3440 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 18/08/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 15/09/2008
Previous Run	: 39964	Qty:	10 Um: Each
Written By	:		
Checked & Approved By	: <u>JLO 08.8.18</u>		
Comment	: Est. A 05.07.13 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
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3.457 f(s)



Comment: Qty.: 0.3457 f(s)/Unit Total : 1.3826 f(s)

6061 T6 1.25 X 1.25"

Material: 6061-T6 or 6061-/651/T6510/T6511/T62 Bar (QQ-A-225/8)

(M6061T6B1.250x01.250)

Identify for D3440-3

Batch #: M107744

M.A 08/08/21

(16)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank 3.950" long

M.A 08/08/21

(16)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA538 and Dwg D3440

Dwg Rev: A

Identify as D3440-3

Folio Rev: A

Deburr

M.A 08/08/27

(16)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 08/08/27

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 18/08/2008 10:22:42 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE GUIDE

Job Number: 41277

Part Number: D34403

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*ml 08/08/27*

(10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*ml 08/08/28*

(10)

7.0

POWDER COATING

POWDER COATING



*M 102316*



(10)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

*3:10*

OVEN TEMPERATURE:

*320 °F*

FINISH TIME:

*3:40*

*ml 08/08/28*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*ml 08/08/28*

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *134*

*08/08/28*

(10)

*SL*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Doeloebe*

(10)

Job Completion



*U 08.08.29*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

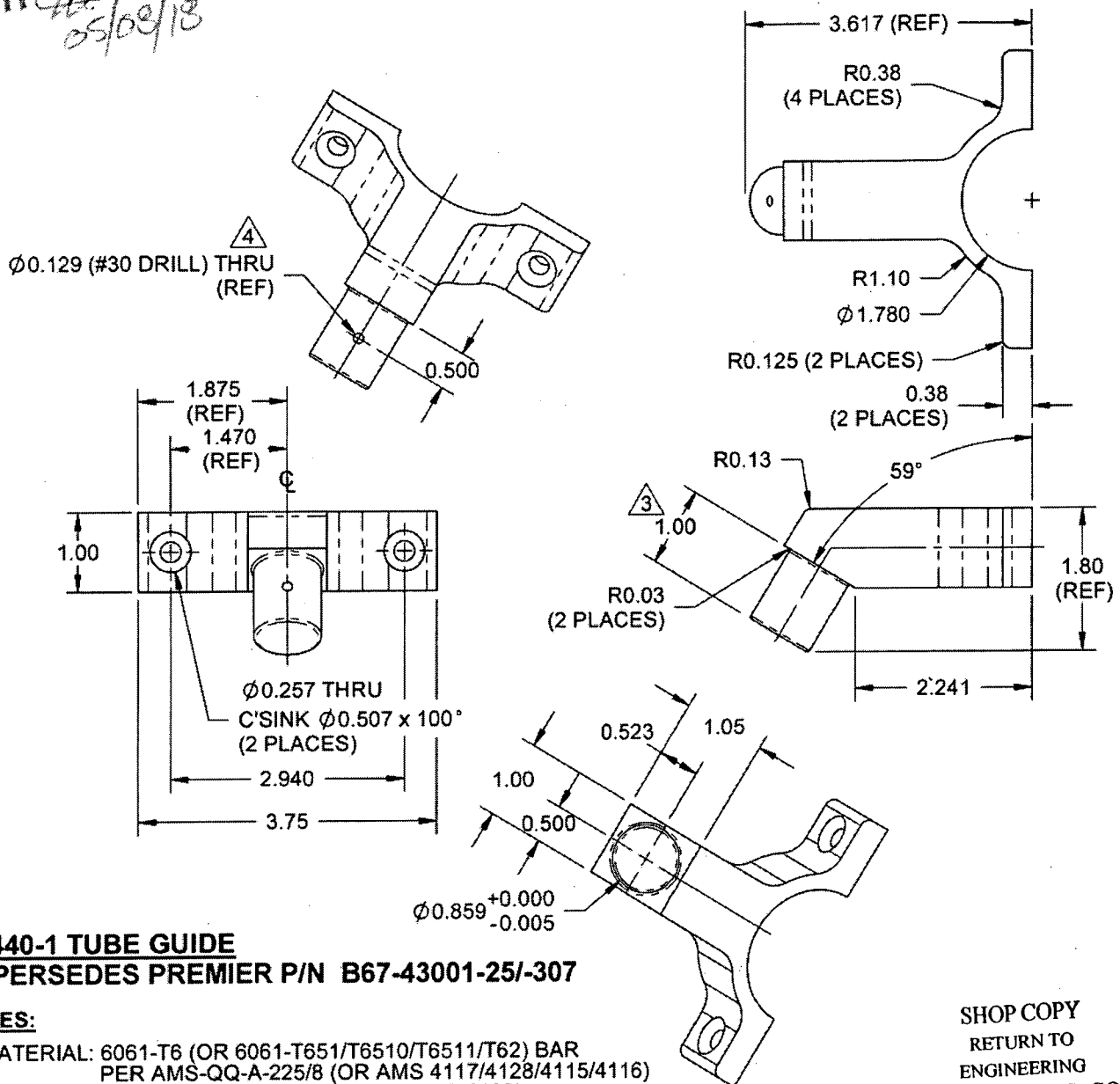
**NOTE:** Date & initial all entries



**DART**

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DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:2
A	05.06.02	NEW ISSUE	

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05/09/13

**D3440-1 TUBE GUIDE****SUPERSEDES PREMIER P/N B67-43001-25/-307****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A/200/8 (OR AMS 4160) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 3) MASK BEFORE PAINTING.
- 4) DRILL HOLE AT ASSEMBLY.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

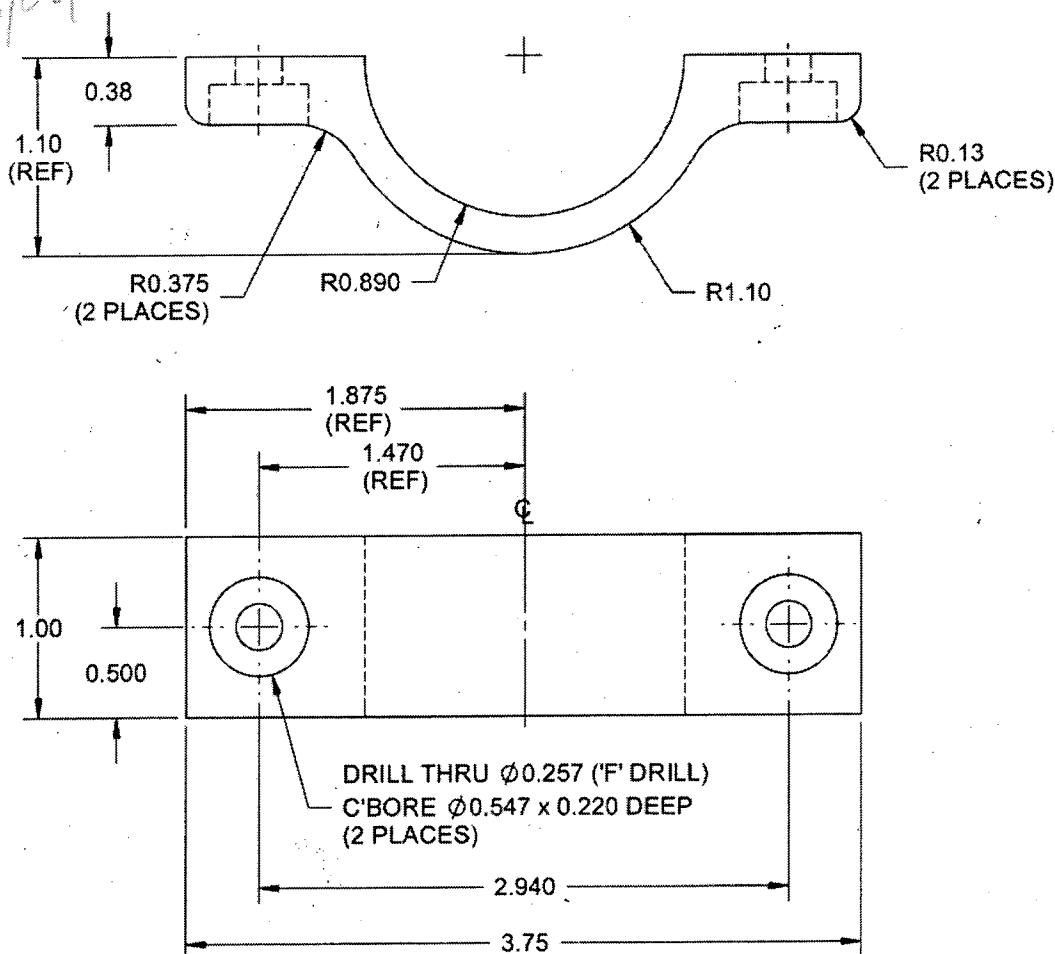
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



### **D3440-3 CLAMP**

**SUPERSEDES PREMIER P/N B67-43001-309**

#### **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QT/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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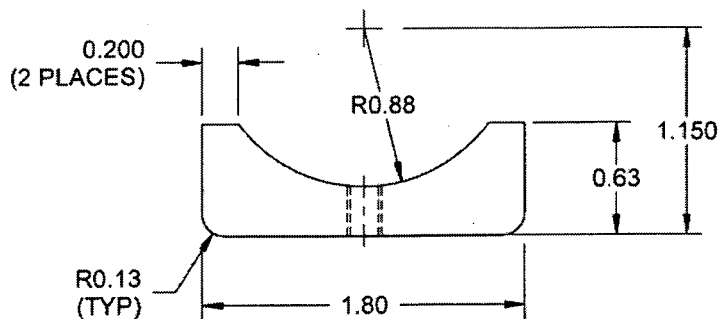
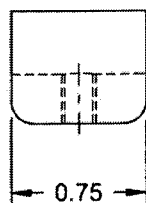
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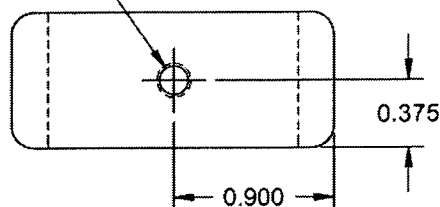


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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

RELEASED  
*[Signature]*  
05/08/18



DRILL  $\varnothing 0.159$  THRU,  
TAP #10-32 UNF THRU



**D3440-5 CONTOURED DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-217**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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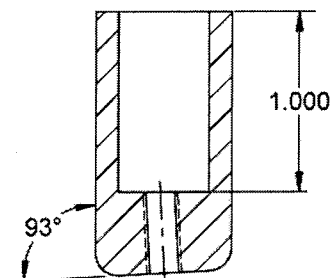
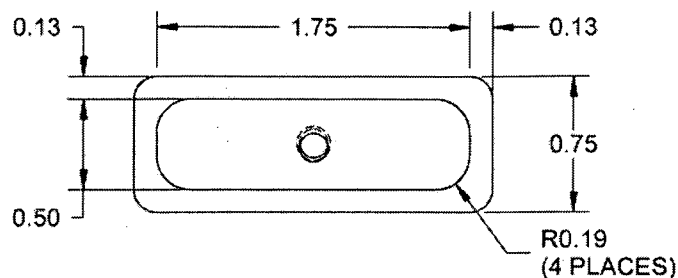
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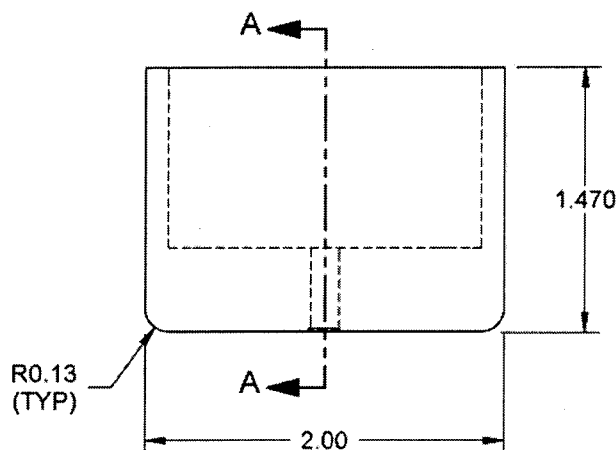
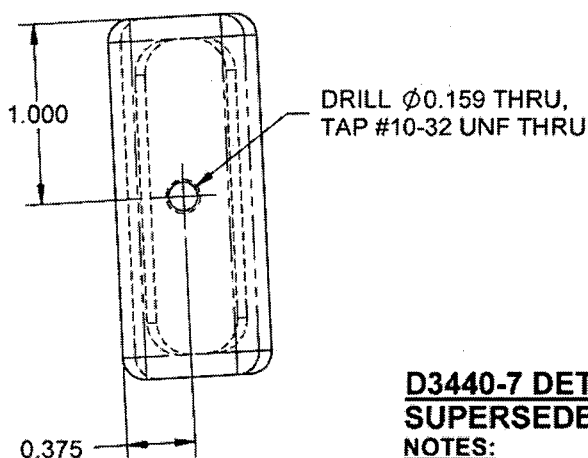


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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1

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05/03/13



SECTION A-A



**D3440-7 DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-221**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) ENGINEERING  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

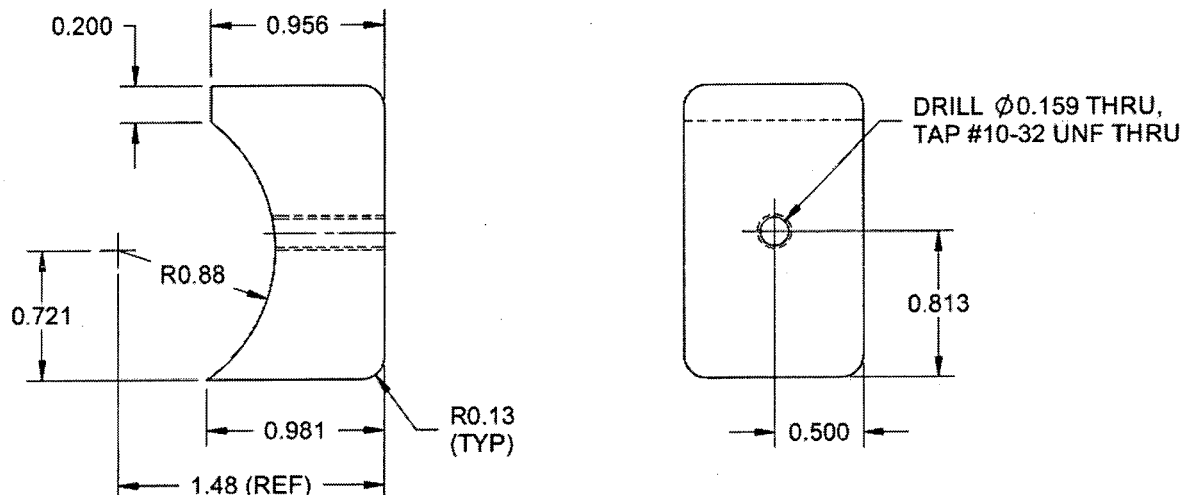
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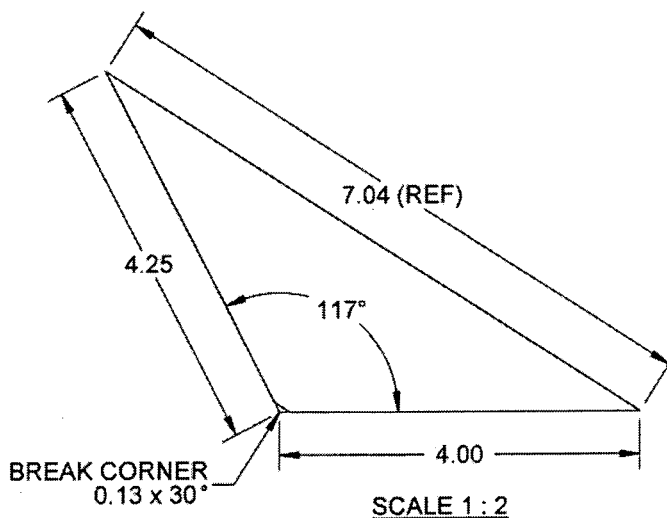
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DATE <b>05.06.02</b>		TITLE <b>BLADE FOLD KIT PARTS</b>	SCALE 1:1



**D3440-9 TUBE DETENT CLIP BASE**  
**SUPERSEDES PREMIER P/N B67-43001-241**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS-QQ/A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)

**RELEASED**  
*[Signature]*  
05/08/13



**D3440-11 GUSSET**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.250)

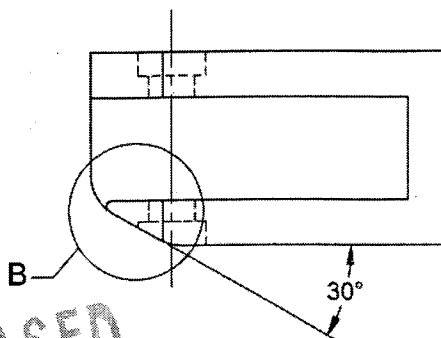
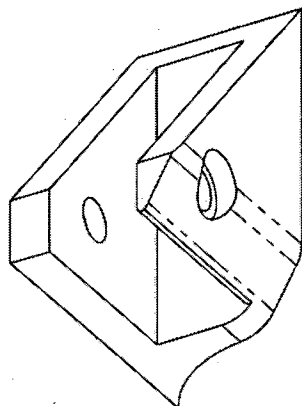
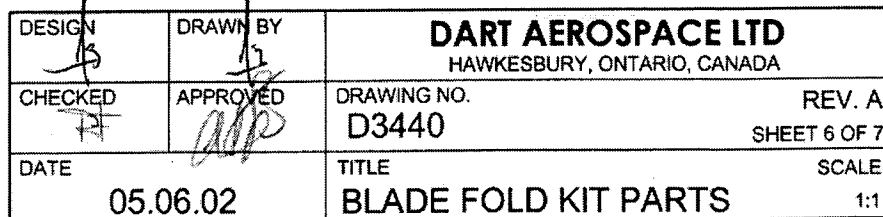
**NOTES:**

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

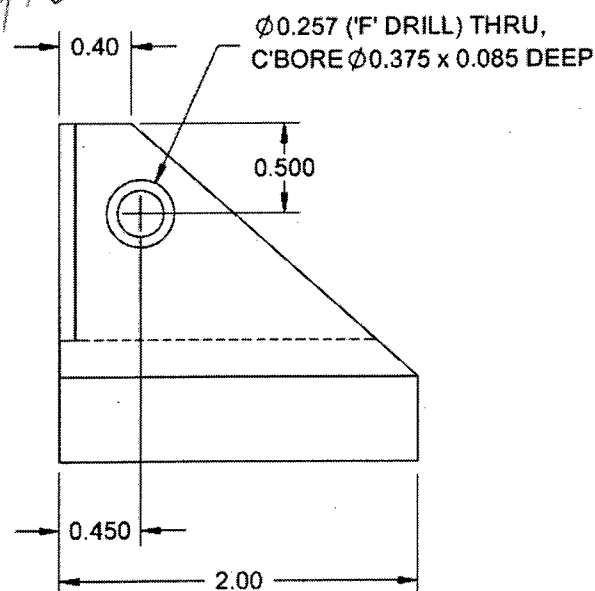
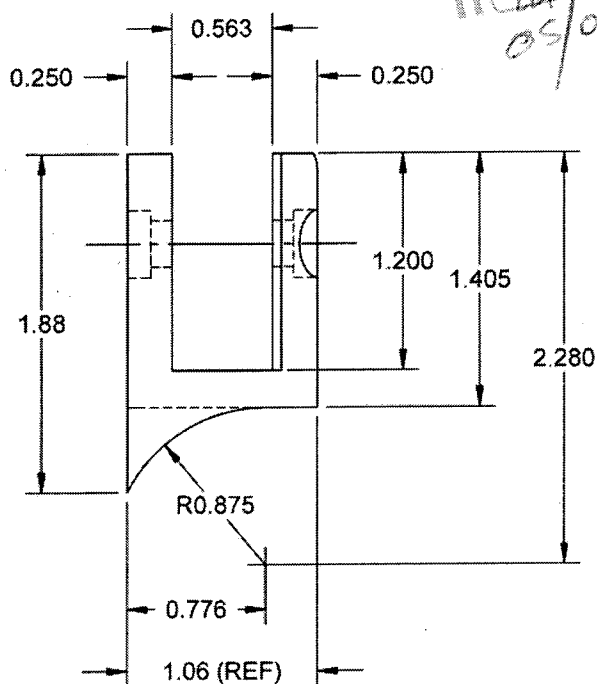
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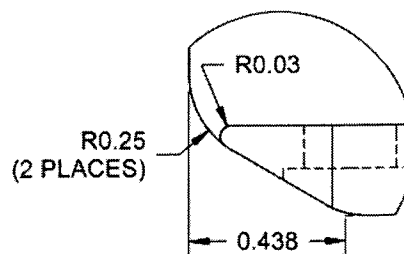


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**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-/651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR PER AMS/QQ/A/200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010



DETAIL B  
SCALE 2 : 1

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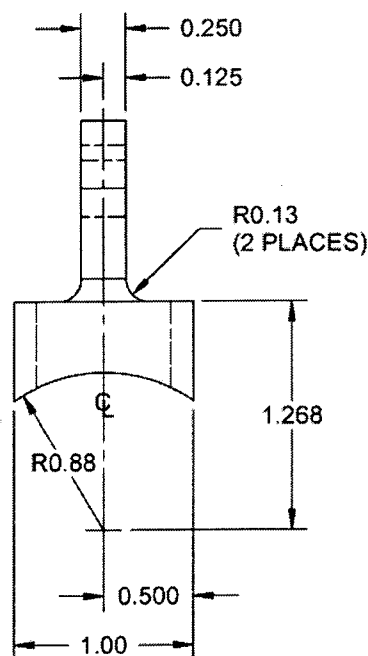
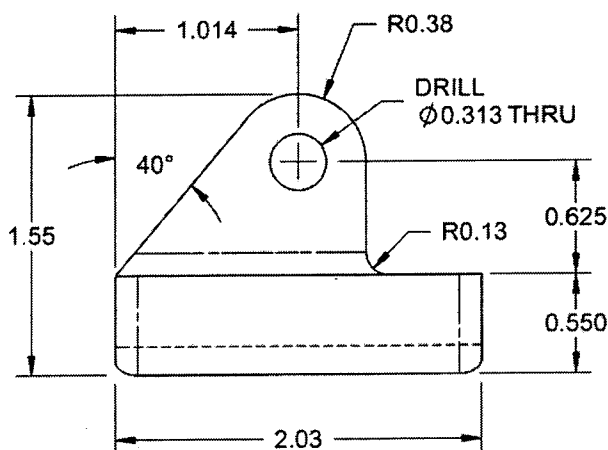
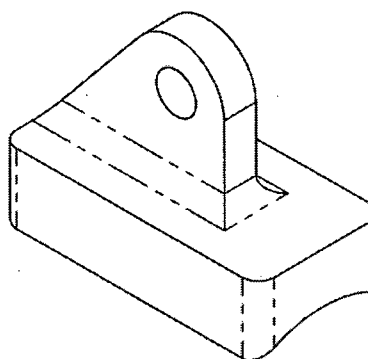
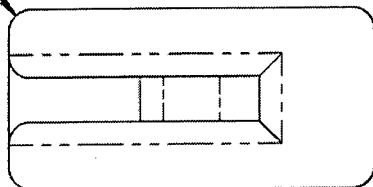
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DATE <b>05.06.02</b>	TITLE <b>BLADE FOLD KIT PARTS</b>		SCALE 1:1

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*[Signature]*  
05/08/18

R0.13  
(4 PLACES)



**D3440-15 CONTOURED MALE EYE  
SUPERSEDES PREMIER P/N B67-43001-215**

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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